
वस्त्रादि — टेक-अप रोलर्स के लिए छिद्रित
स्ट्रिप्स — विशिष्टि
(पहला पुनरीक्षण)

**Textiles — Perforated Strips for
Take-Up Rollers — Specification**
(*First Revision*)

ICS 59.120.30

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FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Textile Machinery and Accessories Sectional Committee had been approved by the Textiles Division Council.

This standard was revised in 1967. The standard has been revised to incorporate the following changes:

- a) Marking clause has been modified; and
- b) Sampling clause has been modified.

The composition of the Committee responsible for the formulation of this standard is given in Annex A.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

TEXTILES — PERFORATED STRIPS FOR
TAKE-UP ROLLERS — SPECIFICATION

(First Revision)

1 SCOPE

This standard prescribes requirements of perforated steel strips (fillets) used for covering take-up rollers of plain looms.

2 MANUFACTURE**2.1 Material**

Fillets shall be made from cold-rolled bright mild steel strips. The carbon content of the steel strip shall be 0.08 percent (*Max*).

2.2 Workmanship and Manufacture

The strip should be punched to form holes all over the surface (*see* Fig. 1) in such a way that the edges of the holes protrude out of the surface of the strip making it rough. No hole shall cut the edge of strip on either side.

NOTE — If prescribed by the buyer, brass sheet may be used for the manufacture of fillets.

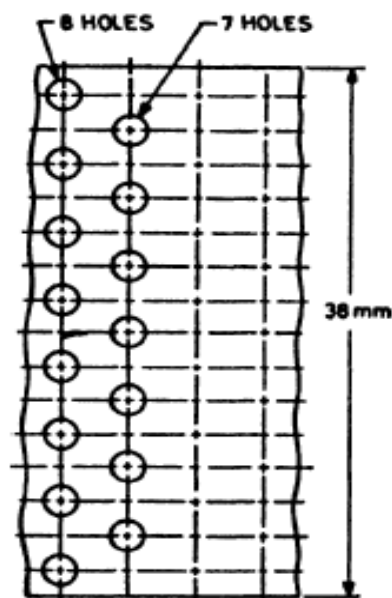


FIG. 1 STAGGERING OF 7/8 HOLES IN A FILLET

2.3 Roughness of Fillet

The surface of the fillet should be rough to such an extent that it does not allow the woven cloth to slip over it (that is, it grips the cloth) and at the same time does not damage the cloth in any way.

2.4 Finish

The fillet shall be given an anti-rust finish.

3 REQUIREMENTS**3.1 Width**

The width of the fillet shall be 38 mm.

3.2 Thickness

The thickness of the strip shall be 0.150 mm to 0.213 mm (or 38 SWG to 35 SWG).

3.3 Pattern

As agreed to between the buyer and the seller, the pattern of the fillet (staggering of holes) shall be 7/8, 9/10, 11/12, 16/17, 19/20 or 21/22. The staggering of holes in the fillet shall be as shown in Fig. 1.

3.3.1 7/8 holes means that there are 7 holes in a line across the width of the fillet and in the adjacent line there are 8 holes staggered as shown in Fig. 1.

3.3.2 The number of holes across the width of the fillet depends upon the quality of the cloth to be woven. The number of holes and quality of cotton cloth is given below for the information and guidance of the buyer and the seller:

Sl No.	Pattern	Quality of Cloth
(1)	(2)	(3)
i)	7/8	Coarse
ii)	9/10, 11/12	Medium
iii)	16/17	Fine
iv)	19/20, 21/22	Superfine

3.3.3 Diameter of holes and number of rows of holes per 5 cm along the length of the fillet in respect of various patterns should generally be as follows:

<i>Sl No.</i>	<i>Pattern</i>	<i>Diameter of Hole, mm</i>	<i>Number of Rows/5 cm Along Length of Fillet</i>
(1)	(2)	(3)	(4)
i)	7/8	1.2	12
ii)	8/9	1.2	16
iii)	9/10	0.8	16
iv)	11/12	0.8	22
v)	16/17	0.4	26
vi)	19/20	0.4	26
vii)	21/22	0.4	32

4 SAMPLING

4.1 Lot

All the rolls of fillets of the same pattern and manufactured from the same kind of material delivered to a buyer against one despatch note shall constitute a lot.

4.2 The conformity of the lot to the requirements of this standard shall be determined on the basis of the tests carried out on the sample drawn from it.

4.3 Unless otherwise agreed to between the buyer and the seller, the number of rolls to be selected at random shall be according to col (2) and col (3) of Table 1.

4.4 The rolls selected according to 4.3 shall be tested for width, thickness and pattern.

4.5 Criteria for Conformity

The lot shall be declared as conforming to the requirements of this standard, if the number of rolls found defective in respect of any one or more of the characteristics tested in 4.4 does not exceed the corresponding number given in col (4) of Table 1.

5 MARKING

5.1 Each roll of fillet (*see* 6.1) shall be marked at an appropriate place with the following:

- Pattern (*see* 3.3);
- Width and thickness;
- Gross and net mass;
- Lot/batch number; and
- Manufacturer's name, initials or trade-mark.

5.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the Standard Mark.

6 PACKING

6.1 A length of 150 m of fillet shall be wrapped in the form of a roll. The roll shall then be oiled and wrapped with an inner layer of waterproof packing paper and finally with an outer layer of hessian.

6.1.1 The package shall bear the following information:

- Length of the fillet;
- Pattern; and
- Name, initials or trade-mark of the manufacturer.

Table 1 Sample Size and Permissible Number of Non-conforming Rolls

(Clauses 4.3 and 4.5)

Sl No.	Number of Rolls in the Lot	Number of Rolls to be Selected	Permissible Number of Non-conforming Rolls
(1)	(2)	(3)	(4)
i)	Up to 150	8	1
ii)	151 to 280	13	1
iii)	281 to 500	20	2
iv)	501 and above	32	3

ANNEX A*(Foreword)***COMMITTEE COMPOSITION**

Textile Machinery and Accessories Sectional Committee, TXD 14

<i>Organization</i>	<i>Representative(s)</i>
Central Manufacturing Technology Institute, Bengaluru	DR NAGAHANUMAIAN (Chairperson)
Amritlakshmi Machine Works, Mumbai	SHRI N. K. BRAHMACHARI SHRI N. K. RAUT (<i>Alternate</i>)
ATE Enterprises Private Limited, New Delhi	SHRI ABHIJIT KULKARNI SHRI ANIL KUMAR SHARMA (<i>Alternate</i>)
Bajaj Industries Private Limited, Kolkata	REPRESENTATIVE
Bhowmick Calculator, Kolkata	SHRI GOUTAM BHOWMICK SHRI VIVEKANANDA BHOWMICK (<i>Alternate</i>)
Central Manufacturing Technology Institute, Bengaluru	SHRI B. R. MOHANRAJ SHRI K. SARAVANAN (<i>Alternate</i>)
Confederation of Indian Textile Industry, New Delhi	SHRI AJAY KUMAR
Dashmesh Jacquard and Powerloom Private Limited, Panipat	SHRI RAJMEET DHAMMU (<i>Representative</i>)
HLL Lifecare Limited, Noida	SHRI AKHIL G. S. SHRI RATNAKAR GUPTA (<i>Alternate</i>)
ICAR-Central Institute for Research on Cotton Technology, Mumbai	DR N. SHANMUGAM DR T. SENTHILKUMAR (<i>Alternate</i>)
India ITME Society, Mumbai	SHRI PRASHANT MANGUKIA SHRIMATI SEEMA SRIVASTAVA (<i>Alternate</i>)
Indian Jute Industries Research Association, Kolkata	SHRIMATI SAUMITA CHOUDHURY SHRI PARTHA SANYAL (<i>Alternate</i>)
Indian Jute Mills Association, Kolkata	REPRESENTATIVE
Indian Textile Accessories and Machinery Manufacturers Association, Mumbai	SHRI N. D. MHATRE SHRI CHANDRESH SHAH (<i>Alternate</i>)
Inspiron Engineering Private Limited, Ahmedabad	SHRI SANJAY KOWARKAR SHRI ANKUR SONI (<i>Alternate</i>)
JCB Industries, Guwahati	SHRI DHRUBA SARMA SHRI ABHIJIT BHUYAN (<i>Alternate</i>)
Kusters Calico Machinery Limited, Karjan	SHRI DEVANG PARIKH SHRI SHUBHASIS SUR (<i>Alternate</i>)
Lakshmi Machine Works Limited, Coimbatore	MS KALPANA A. MS DIVYA V. (<i>Alternate</i>)
Laxmi Shuttleless Looms Private Limited, Ahmedabad	SHRI KETAN SANGHVI
Ludlow Jute Limited, Kolkata	REPRESENTATIVE

<i>Organization</i>	<i>Representative(s)</i>
Ministry of Heavy Industries and Public Enterprises, Department of Heavy Industry, New Delhi	SHRI SANJEEV GUPTA SHRI S. SUNDAR (<i>Alternate</i>)
National Safety Council, Navi Mumbai	SHRI LALIT R. GABHANE SHRI R. R. DEOGHARE (<i>Alternate</i>)
Office of the Textile Commissioner, Mumbai	SHRI C. R. KALESAN SHRI JAGRAM MEENA (<i>Alternate</i>)
Peass Industrial Engineers Private Limited, Navari	SHRI RAVI S. RAO SHRI JIGNESH B. PATEL (<i>Alternate</i>)
Technocraft Industries India Limited, Mumbai	SHRI RAVINDER KUMAR SHRI DURADUNDESHWAR HIREMATH (<i>Alternate</i>)
Textile Machinery Manufacturers Association, Mumbai	SHRI M. SHANKAR SHRI PRASHANT MANGUKIA (<i>Alternate</i>)
The Bombay Textile Research Association, Mumbai	SHRI VIJAY GAWDE SHRI R. A. SHAIKH (<i>Alternate</i>)
The Synthetic and Art Silk Mills Research Association, Mumbai	DR MANISHA MATHUR SHRI SANJAY SAINI (<i>Alternate</i>)
The Textile Association (India), Mumbai	SHRI J. B. SOMA SHRI ASHOK JUNEJA (<i>Alternate</i>)
Truetzschler India Private Limited, Ahmedabad	SHRI PRAVIN KANDGE SHRI SHILADITYA JOSHI (<i>Alternate</i>)
United Nations International Children's Emergency Fund, New Delhi	DR PRATIBHA SINGH SHRI YUSUF KABIR (<i>Alternate</i>)
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BIS Directorate General	SHRI J. K. GUPTA, SCIENTIST 'E'/DIRECTOR AND HEAD (TEXTILES) [REPRESENTING DIRECTOR GENERAL (<i>Ex-officio</i>)]

Member Secretary
SHRI SWAPNIL
SCIENTIST 'B'/ASSISTANT DIRECTOR
(TEXTILES), BIS

Bureau of Indian Standards

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Amendments Issued Since Publication

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